

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006440**Date Inspected:** 22-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhao Chen Sun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Dilip Chakrabarti was present during the times noted above for observations relative to the work being performed.

Bay# 6-Tower Assembly:

This QA Inspector randomly observed the following work in progress:

**SMAW Process:**

Welding of weld joint# B/B24 located on PCMK ESD1 DPSA4-4. Welder is identified as 068250. ZPMC QC is identified as Liu Zhi. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3313-TC-P5.

Welding of weld joint# B/B25 located on PCMK ESD1 DPSA4-4. Welder is identified as 037779. ZPMC QC is identified as Liu Zhi. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3313-TC-P5.

Welding of weld joint# B/B13 located on PCMK ESD1 DPSA4-4. Welder is identified as 066416. ZPMC QC is identified as Liu Zhi. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3312-TC-P5.

Welding of weld joint# B/B14 located on PCMK ESD1 DPSA4-4. Welder is identified as 068088. ZPMC QC is identified as Liu Zhi. The welding variables recorded by QC appeared to comply with the specified WPS no.

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## WELDING INSPECTION REPORT

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B-T-3312-TC-P5.

Bay # 5-OBG Assembly:

This QA Inspector randomly observed the following work in progress:

Ultrasonic Testing:

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 UT report on this date.

The member and the weld designations are as follows:

Sl #	Section #	Weld #	Green Tag #	Location
1.	CB 202B-006	001,002,003,004	NA	NA
2.	FB 205-009	05,09,13,19	NA	NA
3.	FB 205-010	05,09,13,19	NA	NA
4.	FB 205-011	05,09,13,19	NA	NA
5.	FB 205-012	06,12,16,22	NA	NA
6.	FB 204-009	18,24,25,31,37,43,06,12	NA	NA
7.	FB 204-010	18,24,28,34,40,46,06,12	NA	NA
8.	FB 204-011	18,24,28,34,40,43,06,09	NA	NA
9.	FB 204-012	18,24,25,31,37,46,05,09	NA	NA

Unless otherwise noted, all work observed on this date appeared to be generally comply with applicable contract document

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Chakrabarti,Dilip Kumar	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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